

Work Order ID 71865 -2

Wednesday, July 13, 2011 11:02:01 AM

Split



Page 1

Item ID: D2648-3

Revision ID:

Item Name: Wearpad

Start Date: 7/14/2011 Start Qty: 10.00

Required Date: 7/28/2011 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: *muf*

Date: 11-07-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2648

Rev D

100



Waterjet

FLOW WATER JET

0.00

0.00

11/07/26

28

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D2648

*****CUT WITH FILE D2648-1*****

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

11/07/26

28

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71865

Wednesday, July 13, 2011 11:02:01 AM



Page 2

Item ID: D2648-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 7/14/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

11/7/27

28

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

N/A

140



Brake NC

Brake NC

NC BRAKE

Memo

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.
2-Identify as D2648-3

0.00

0.00

SB 11/6/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71865

Wednesday, July 13, 2011 11:02:01 AM



Page 3

Item ID: D2648-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 7/14/2011 Start Qty: 10.00



Required Date: 7/28/2011 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

Weld per dwg A/R Hardcoat steel Batch: *M117864* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D2648 using Jig DT 8210
2-Remove any weld that penetrated through Wearpad if necessary

EL 11-7-27 216

166

QC10- Inspect visual per QSI004- ground welds 0.00



QC

Memo

0.00

Quality Control

EL 11-07-28 16 0

170

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

EL 11 07 28 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71865

Wednesday, July 13, 2011 11:02:01 AM



Page 4

Item ID: D2648-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 7/14/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30
320 OF
10:00

16x Ø m-11/08/02

190

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

16 Ø 11/08/02

200

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

0.00

FP 16

16x Ø m-11/08/02

M117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71865

Wednesday, July 13, 2011 11:02:01 AM



Page 5

Item ID: D2648-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 7/14/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ek 11/08/02

11-08-2
(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 11:01:59 AM

Page 1

Work Order ID: 71865

Parent Item: D2648-3

Parent Item Name: Wearpad



Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF
IPP Rev:F Now on Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S16GA		Purchased	No			100	sf	150.5000	0.075	0.789474			



1010#1025 sheet 16GA



Location

MAT019

116791

117500

Loc Qty

150.5

32.5

118

Loc Code

~~2.8~~
3.2

11/07/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

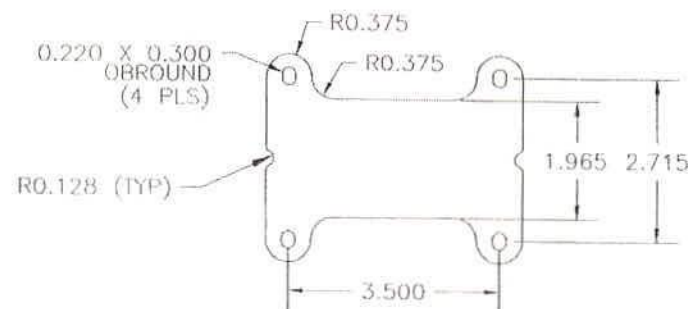
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

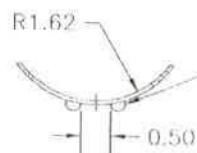
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2648-1 FLAT PATTERN

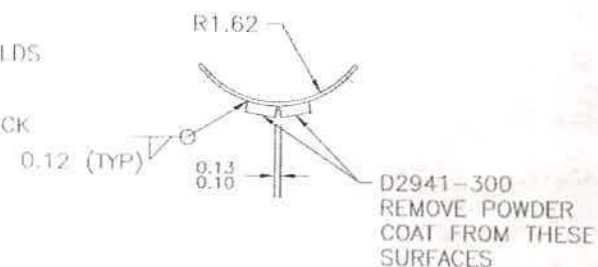


SECTION A-A

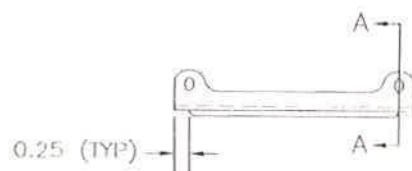


7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

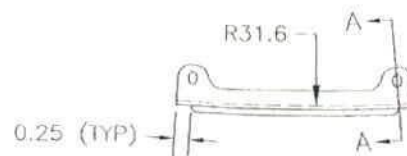
SECTION B-B



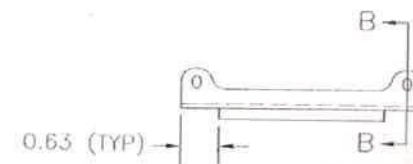
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

RELEASED
1997.11.17



D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE		TITLE WEARPAD
99.11.17		SCALE 1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries